Work Order Wednesday, June 0	ID 120233 4, 2014 2:59:28 PM		*120	0233 *			5	$\omega \wedge$	<i></i>	Page 1
Item ID: Di	3458-1		Accept	*N900	1040	100	<u>n</u> * :	Setup Star	t *N	S1*
	ep Mounting Plate				e de			Stop	*NI	S2*
Start Date: 6/0	04/14 Start Qty: 20	.00 *20 *	•	Cust Item	ID:					. 17
Required Date: 6/0 Reference:	= •			Customer						
Approvals: P	rocess Plan: MUD	Date: <u>\\-\-\</u>	Tooling:	I	Date:	_	I	Run Star	^IVI	R1*
	PC:			I)ate:			Stop	, *N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			1 100						
D3458	Rev A									
100			0.00							
100	FLOW WATER J	ET					(21)		mm	14/07/6
Waterjet	Memo		0.00							-
FLOW CNC Waterjet	Dwg I Prog I	as per Dwg D3458 Rev: A Rev: A Durr if necessary								
¥										
110	QC2- Inspect parts	s off machine FAI/FAIB	0.00							
*11 0 *							(z_1)		17. A	14/07/16
QC	Memo	0	0.00				<u> </u>		MM	1160116
Quality Control										
			DAS 27	S						
120	QC8- Inspect parts	s - second check	e fe 00.0)			\bigcirc 1			
120			١, ١	. 1,7			21			
QC	Mem	0	0.00	1116						
Quality Control			ì	• -						

DQA:			Date:											
						WORK ORDER NON	-CC	ONFO	RMANCE / UP			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
Work Orde	er: -					.	1		ctical and a	C	7	Water Jet		Fnging aring [
Part N	J۸					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	\dashv	Engineering Quality
l aren	•••					Use-as-is	1	t .	noforming	Finishing		re/Packaging		Other
NCR N	lo.					Suspected Unapproved		1110111	Large Fab	Composite	1	Supplier		
	•						•				-	· ·		
Root					Desc	ription of work order update	I	nitial	Actio	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	n	QC Inspector
Design							1							
Doc/Data												}	-	
Equip/Tooling		!		:									1	
Handling/Pre														
Material			, !	i									1	
Operator														
Offset/Setup											İ		1	
Process														
Supplier									Ì					
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Transport														
Unapproved						· 			<u> </u>		<u> </u>	<u></u>		
							FA	ULT CA	TEGORY	4				<u>-</u>
Landi	_	1				General	_	1 /-	_	_	7	. 1		D /F
	Щ	Bending		•	<u> </u>	Bend	\vdash	1	Program	<u> -</u>	Outside Dim		_	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under		\vdash	Set-up
	Ш	Cracks			\vdash	Broken/Damage/Defect	-	Hardwa		<u> </u>	Part Incorre			Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	\vdash	4 `	ion Incomplete/Un		Part Lost/M		\vdash	Weld
		Cuffs				Contamination	-	4	tions Incomplete/U	nclear	Part Moved			Wrong Stock Pulled
, .		Crushing			\vdash	Countersink	_	-1	gned/off center	<u> </u>	Positioned V Power Loss/			Other
	Н	Heat Trea			.	Cut Too Short	<u> </u>	Mislabe		<u> </u>	Trower ross/	ourge		Other
	-	Inspection		Tube	\vdash	Drawing	\vdash	Misrea						
	\vdash	Marks/Ch			<u> </u>	Drill Holes	<u> </u> -	Off-set						
	\sqcup	Turning S			\vdash	Finish	\vdash	4	Calibration					
		Wave/Tw	ist in Tub	e	L_	Fit/Function	1	Out of	Sequence					

120233

Page 2

Wednesday, Jun	e 04, 2014 2	:59:28 PM									
Item ID: Revision ID: Item Name:	D3458-1 Step Mountin	g Plate		Accept	*N900	040	100)* s	Setup Star	·· I VI ·	S1* S2*
Start Date: Required Date: Reference:	6/04/14	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:				Y I XI.	
Approvals:	Process Pla	an:	Date:	Tooling: _ SPC (Y/N):		ate:		R	Run Stai Sto	^ \	R1* R2*
Sequence ID/ Work Center II 130 *130*	D	Operation Description Small Fab		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 19
Small Fab Small Fab		Memo Deburr parts	s per dwg D3458	0.00 DAS 19	NA	1				-	9-89
140		QC5- Inspect part compl	eteness to step on W/O	9 -89							Das 19
140 QC Quality Control		Memo		. 0.00							9-89
150		Identify as per dwg & St	ock Location: WA .	3 0.00				- 1	-/		N
150 Packaging Packaging		Memo *** STOCK	X IN STEP CELL***	0.00				_2[_	9_	_	14.01:
;		37000			•				•		·

DQA:			Date:						_					"DART
						WORK ORDER NON-	·CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:			Date:				₁				Wo	ork Order up	date only	
Work Orde	٠.					DISPOSITION		: 		AGAINST	DE	PARTMENT	/PROCESS	
WOIK OIGE	٠					Rework			Skid-tube ·	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality
	•	· · · · ·				Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	
Root	7				Desci	ription of work order update		nitial	Actio	on		Sign &		
Cause	ļ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion		Date	Verification	QC Inspector
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Offset/Setup						•	ŀ	_						
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Supplier 🚍 🗓						<u> </u>	ļ	,•.						
Training														
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Unapproved		i	L	<u> </u>			<u> </u>							J
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		Centre No	ot Concer	ntric	-	BOM/Route Broken/Damage/Defect	\vdash	Grain	aro.	•	├	Part Incorred	—	Temperature/Cure
	_	Cracks Crimp/Kir	d /Binnla	Maya	\vdash	Burrs	_	Hardwa	ire ion Incomplete/Unq	malified	\vdash	Part Lost/Mi		Weld
	_	Crimp/Kir Cuffs	ıv) vibbie	y wave	-	Contamination	\vdash	4	tions Incomplete/Ur		<u> </u>	Part Moved	-	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	\vdash	4	gned/off center	ioicui	—	Positioned V	∟ Vrong	
		Heat Trea	ıt			Cut Too Short	-	Mislabe				Power Loss/		Other
		Inspection		Tube	\vdash	Drawing	\vdash	Misrea			<u> </u>]	· _	
	_	Marks/Ch			\vdash	Drill Holes	\vdash	Off-set						
		Turning S				Finish		4	Calibration					
,		Wave/Tw				Fit/Function		4	Sequence					

W	orl	k '	Orde	r	I	D	1	2	02	33	3
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120233

Page 3

Wednesday, J	une 04, 2014	2:59:28 PM											
Item ID: Revision ID:	D3458-1			Accept	*N900	040	100)* 8	Setup	Start	*N	S1*	
Item Name:	Step Mount	ing Plate								Stop	*N	S2*	
Start Date:	6/04/14	Start Qty: 20.00	*20*		Cust Item 1	D:							
Required Dat	te: 6/04/14	Req'd Qty: 20.00	*20*		Customer:								
Reference:			,										
Approvals:	Process P	Plan:	Date:	Tooling:	D	ate:		F	Run	Start	*N	R1*	
ţ ·	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	-	Reject Number	Insp. Stamp	
160		QC21- Final Inspection -	Work Order Release	0.00									
160 QC Quality Control		Мето		0.00				MC=	-	14-	570	2	-

My. 7.21

WORK ORDER NON-CONFORMANCE / UPDATE Work Order: Work Order: Part No. WORK ORDER NON-CONFORMANCE / UPDATE Work Order update on AGAINST DEPARTMENT/PROCES Rework Scrap Machining Small Fab Prod. Eng. C	ss
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCES Rework Skid-tube Crosstube Water	ss
Work Order: Rework Skid-tube Crosstube Water	
Rework Skid-tube Crosstube Water	er Jet Engineering
	Coor. Quality
Use-as-is Thermoforming Finishing Rec/Store/Packa	
	plier
	#A
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verific	cation QC Inspector
Design	,
Doc/Data	
Equip/Tooling	
Handling/Pre Handling/Pre	979
Material	***
Operator	
Offset/Setup Offset/Setup	
Process	
Supplier	
Training	
Transport 1	
Unapproved FAULT CATECORY	
FAULT CATEGORY	
Landing Gear General Bending Bend Folio/Program Outside Dimensions	Pressure/Forced
Bending Bend Folio/Program Outside Dimensions Centre Not Concentric BOM/Route Grain Over/Under tolerance	
Cracks Broken/Damage/Defect Hardware Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing	Weld
Cuffs Contamination Instructions Incomplete/Unclear Part Moved	Wrong Stock Pulled
Crushing Countersink Misaligned/off center Positioned Wrong	
Heat Treat Cut Too Short Mislabeled Power Loss/Surge	Other
Inspection Strip in Tube Drawing Misread	<u> </u>
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

14/07/16

Wednesday, June 04, 2014 2:59:28 PM

Work Order ID: 120233

120233

Parent Item:

D3458-1

D3458-1

Parent Item Name: Step Mounting Plate

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 20.00

**

Required Qty: 20.00

Comments:

IPP REV. A 05.12.13 NEW ISSUE

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00		Purchased	No		100	f	16.1168	0.0427	0.898948	3		

M6061T6B0 187X04 000



Location Loc Oty Loc Code MAT051 16.116842 m128265 16.116842

m125590

(**10**-00)

10

DQA:		·	Date:		•									TRAC [~]
			_			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:						· .	W	ork Order up	date only		
Work Orde	r:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
	-					Rework]		Skid-tube Crosstube	e		Water Jet		Engineering
Part N	0.					Scrap		i	Machining Small Fal	b	Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Thern	noforming Finishin	g	Rec/Sto	re/Packaging		Other
NCR N	o. -	- · - · · ·		<u> </u>		Suspected Unapproved]		Large Fab Composite	e		Supplier		
Root					Desc	ription of work order update		nitial	Action		Sign &			
Cause	١	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
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Offset/Setup				•	·									
Process											ļ }		١	
Supplier	\sqcup													
Training	_												İ	
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Unapproved							<u> </u>				<u>L</u>	<u> </u>	!	
							FA	ULT CA	TEGORY					
Landin	$\overline{}$					General	_	1 /-			Outside Dim			Pressure/Forced
	_	Bending	_		-	Bend	\vdash	4 `	Program	\vdash	Over/Under		-	Set-up
}	-	Centre No	ot Concer	ntric	-	BOM/Route	\vdash	Grain		\vdash	Part Incorre			Temperature/Cure
	-	Cracks	- L. /p: - !	h	\vdash	Broken/Damage/Defect	-	Hardwa	are ion Incomplete/Unqualified	-	Part Lost/M		-	Weld
<u> </u>	_	Crimp/Kir	ік/кірріе	/wave	\vdash	Burrs	\vdash	4		-	Part Moved	-		Wrong Stock Pulled
1 +		Cuffs			-	Countarion	-	4	tions Incomplete/Unclear gned/off center	\vdash	Positioned \	•		TTTOING STOCK I WILL
		Crushing			\vdash	Countersink Cut Too Short	\vdash	Mislabe			Power Loss			Other
		Heat Trea		Tuba	\vdash	Drawing	\vdash	Misrea		<u> </u>	1. 04461 5033/	-uibc		0.1.01
1 }	$\overline{}$	Inspection Marks/Ch	•	rupe	\vdash	Drill Holes	\vdash	Off-set						
		Turning S			-	Finish	\vdash	4	Calibration					
 	-	Wave/Tw			\vdash	Fit/Function	\vdash	4	Sequence					
1	- 1	** U * C/ I W	ise in rub			1. 19 1 0110001		10000			<u> </u>			

DART AEROSPACE LTD	Work Order:	120233
Description: Step Mounting Plate	Part Number:	D3458-1
Inspection Dwg: D3458 Rev: A		Page 1 of 1

	ARTICLE IN	SPECTIO		01/1.10		
		VI - VIIV	ノハ しロヒ	CKLIST		
Х	First Artic		Proto			
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
+/-0.010	0.433	/		V-Jhaz	·	
+/-0.010	ı					
+/-0.010		/				
+/-0.010						
+0.006/-0.001						
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		DAS				
m	Audited by:	27) 8-5-1],	Prototype App	roval:	N/A
14/07/16	Date:	11/-			Date:	N/A
	+/-0.010 +/-0.010 +/-0.010 +0.006/-0.001 +/-0.010 +/-0.010	Tolerance +/-0.010 -	Tolerance	Tolerance Dimension Accept Reject	Tolerance	Tolerance Dimension Accept Reject Inspection Co

Rev	Date	Change	Revised by	Approy∉d
Α	06.04.28	New Issue	KJ/JLM	

玉

DRAWING NO.

SHEET

Q

DART

AEROSPACE PORT HADLOCK,

USA,

₹ C

05.09.23

STEP NEW

PLATE

05.09.23

ISSUE MOUNTING

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK OKDER NO. 120233 14-06-05

R_{0.125}

1.037

R0.386

D3458-1 STEP MOUNTING PLATE

D3458-3 STEP MOUNTING PLATE

2.041-

3.080

R_{0.125}

Ø0.257

(TYP)

R0.500

Ø0.257

(TYP)

0.703

D2622 **EXTRUSION**

PROFILE

D3458-1/-3 STEP MOUNTING PLATE

MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK (REF DART SPEC. M6061T6S.188)

R0.386

3.080

-D2622

EXTRUSION PROFILE

0.703

NONE 2) FINISH:

R0.437

0.863

2.041

- 3) ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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